

# Work Order ID 51967

September 10, 2009 3:03:16 PM

Page 1

Item ID: D3927-1

Accept

Revision ID: A

Item Name: Guard

Setup Start

Stop

Start Date: 9/14/09 Start Qty: 4.00

Required Date: 9/24/09 Req'd Qty: 4.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: 09-10 Tooling:

Date:

Run Start

QC:

Date: SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3927

A

100

0.00

Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut Blank as file D3927-1\_Blank

B 9-9-16

2

110

0.00

HAAS I

Memo

0.00

HAAS CNC vertical machine #1

HAAS

1-Mill as per folio FA & dwg D,

FOLIO REV: AA

DWG REV: A

m5 9/10/09

2-Deburr as required

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Page 2

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Accept

Setup Start

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Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

mj= 09/09/22

2 0

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

ark 09/09/22

2 0

140

Identify as per dwg & Stock Location: 139A

0.00



Packaging

Memo

0.00

Packaging

9-9-22 @SGP

# Work Order ID 51967

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Page 3

Item ID: D3927-1

Accept



Setup Start



Revision ID: A

Stop



Item Name: Guard

Start Date: 9/14/09 Start Qty: 4.00



Cust Item ID:

Required Date: 9/24/09 Req'd Qty: 4.00



Customer:

Reference:

Run Start

# Picklist Print

September 10, 2009 3:03:15 PM

Page 1

Work Order ID: 51967

Parent Item: D3927-1RevA

Parent Item Name: Guard

Comments: Rev:A new issue

Start Date: 9/14/09

Required Date: 9/24/09

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MDELRLNB1.000X04.0 00		Purchased	No			100	f	10.0000	5.7263			



Delrin Bar

9-9-16

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

10

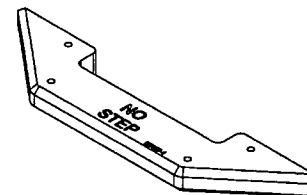
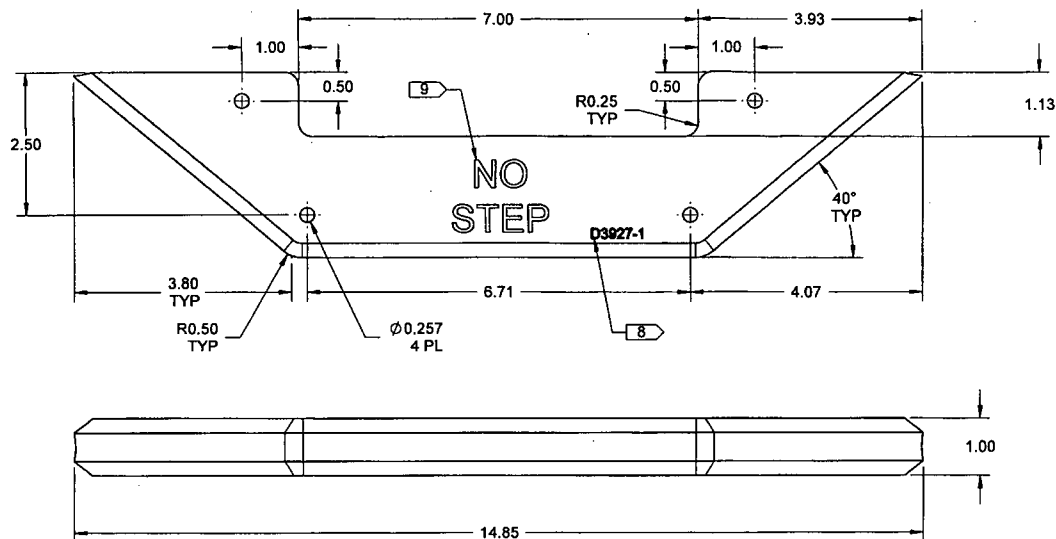
111695

10

111828

111828





**D3927-1 GUARD**

**RELEASED**  
09/17/2009

**NOTES:**

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL 1.0 THICK  
PER DART SPEC M-DELRIN-S1.0
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.90 lbs
- 8) ENGRAVE "D3927-1" TO DEPTH OF 0.005 WITH TOOL TIP RAD OF 0.015±0.005 AT LOCATION INDICATED
- 9) ENGRAVE "NO STEP" TO DEPTH OF 0.005 WITH TOOL TIP RAD OF 0.015±0.005 AT LOCATION INDICATED

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 31967

A		NEW ISSUE		BY		DATE	
REV.		DESCRIPTION					
DESIGN							
DRAWN							
CHECKED							
MFG. APPR.							
APPROVED							
DE APPR.							
DATE							

**DART AEROSPACE USA, INC.**  
PORT HADLOCK, WA

DRAWING NO. **D3927**  
REV. A  
SHEET 1 OF 2

TITLE **GUARD**  
SCALE  
NTS

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